

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019346**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder (OBG)		

Summary of Items Observed:

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSSBEAM CB17

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSSBEAM CB18

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # CROSSBEAM CB19

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG # BAY 10

WELDING INSPECTION REPORT

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This QA observed ZPMC qualified welding personnel identified as 040582 perform Shielded Metal Arc Welding (SMAW) Process on weld joint 29TR1-003,005. ZPMC Quality Control Personnel (QC) identified as Mr. Jiang xian bo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2211-B-U2.

This QA observed ZPMC qualified welding personnel identified as 057220 perform Shielded Metal Arc Welding (SMAW) Process on weld joint 28TR1-014,015. ZPMC Quality Control Personnel (QC) identified as Mr. Jiang xian bo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2211-B-U2.

OBG # SEGMENT LIFT 13

This QA inspector was instructed by Caltrans (CT) QA lead inspector to review, document of radiographic film submitted contractor submittal AFC- CAL-TRN-007819, AFC-CAL-TRN-007817 and AFC-CAL-TRN-00718 by American Bridge Fluor (ABF) and ZPMC. Film reviewed included Radiographic Testing (RT) performed by ZPMC of welds on the Self Anchored Suspension (SAS) Orthotropic Box Girder (OBG) Deck Panel splice welds and Procedure Qualification welds.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
